

Date: Tuesday, 11/21/2006 1:37:28 PM  
 User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG  
 Job Number : 29624  
 Estimate Number : 10008  
 P.O. Number : *N/A* Part Number : D2591  
 This Issue : 11/21/2006 S.O. No. : *N/A* Drawing Number : D2591 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : D  
 Previous Run : 28022 Material : *N/A*  
 Written By : Due Date : 11/28/2006 Qty: 40 Um: Each  
 Checked & Approved By : *JL 06/11/21*  
 Comment : Est Rev: I Removed from 9 Digit 05-10-25 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010B0750X02500 ASTM A21 Steel .75"x2.5"



Comment: Qty.: 0.2340 f(s)/Unit Total : 9.3600 f(s)  
 ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)  
 Batch: *M01926*

*J.L 06/11/30*

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks: 2.700" long

*J.L 06/11/30*

(40)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

*J.L 06/12/01*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L 06/12/01*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*J.L 06/12/01 40*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ED Date: 06/12/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:37:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 29624

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: st51

*PC 4/12/05 40*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



40

Comment: FINAL INSPECTION/W/O RELEASE

*PD 06/12/05*

Job Completion



*u 06.12.05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

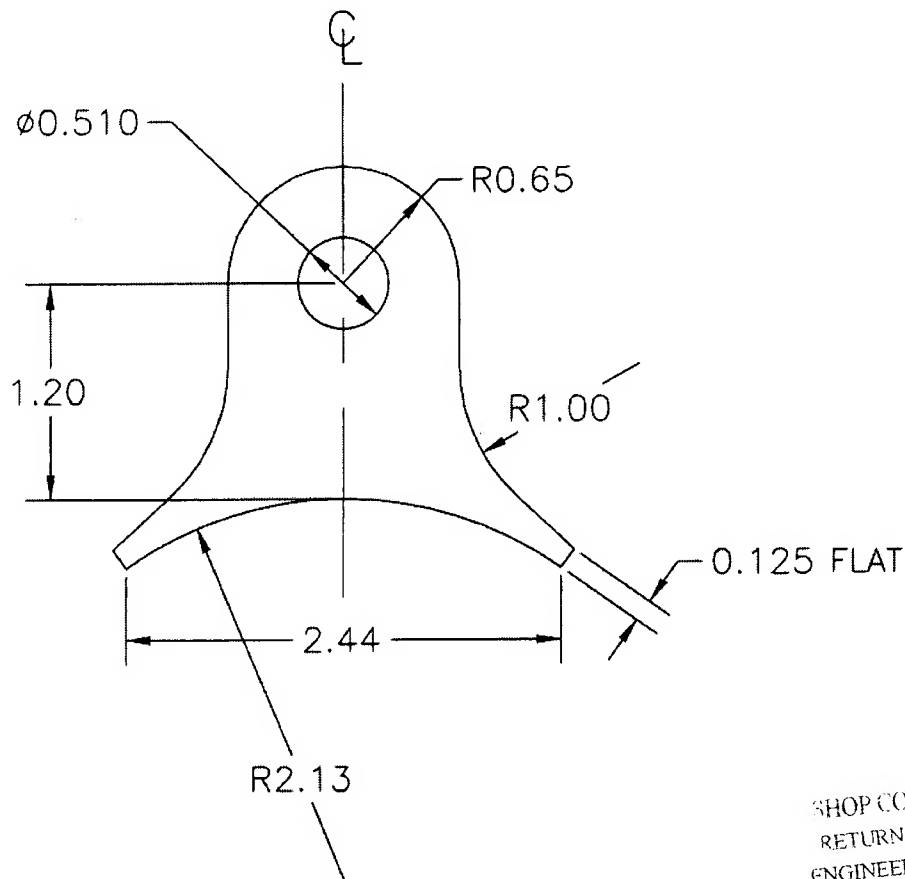
NOTE: Date & initial all entries





DESIGN <i>ME</i>	DRAWN BY <i>ME</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED  
98.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010~~ TO 0.020  
MATERIAL: ASTM A36 STEEL 0.50 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTER-LINE  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29624